

Work Order ID 56807

March 10, 2010 1:30:20 PM



Page 1

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly RH

Stop



Start Date: 10/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

BS

Date: 10-3-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2991	D								
DSI 9463	A								
IIN-D350-589	E								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-042/ DSI 9463
CHG005

8/6/5/14

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

25 10-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start

Revision ID:

Stop

Item Name: Side Door Assembly RH

Start Date: 10/03/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

Prime + Paint as per Q57 005
Paint B 114402
Primer B 114013
ET 10-05-12

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/13



160



Packaging

Pick Kit

0.00

Memo

0.00

10-5-13SP

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	Swelshy			②			Ph →
180 Packaging Packaging	 Memo Identify and pack for shipping as per PPP D350-589-042/ DSI 9463 Location: <u>Re</u> PPP rev: _____	0.00 0.00				10/4/19			
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				10/05/19			

ME

10-5-19

Dart Aerospace Ltd

W/O: 56807		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/5/13	100	Perm. Change Missing Part. ADD to kit - D3895-1 B <u>46897</u> Qty +1 per kit - S. 10/5/13 - D3894-1 B <u>46896</u> Qty +1 per kit - S. 10/5/13	SP	10.5.13	1 1		S 10/5/13	
		update BOM + w/o Per DST 9447 + 9446	PA	10.05.20			S 10/5/13	

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Picklist Print

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Page 1

Work Order ID: 56807

Parent Item: D350-589-042

Parent Item Name: Side Door Assembly RH



Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00


D2991-2 	Manufactured	No	110	Each	0.0000	1.0000	
Side Door							BT 10-05-10
D2621 	Manufactured	No	110	Each	55.0000	1.0000	
Latch Plate, 350 Spacepod							BT 10-05-12

Warehouse
Location

Main Warehouse

ST021

46842

D2586 	Manufactured	No	110	Each	100.0000	1.0000	
Door Latch							BT 10-05-12

Warehouse
Location

Main Warehouse

ST

45554

50213

55314

Main Warehouse

ST204

56416

Loc Qty

Loc Code

96

1

4

91

4

4

x3

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 verified : DD

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased No

110 Each

159.0000 1.0000



Screw



ET 10-05-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

159

112794

59

114056

100

D2464-1700

Manufactured No

110 Each

0.0000 1.0000



Neoprene Seal

D3085-041

Manufactured No

110 Each

6.0000 1.0000



prop ass'y



ET 10-05-13

ET 10-05-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

47186

2

47687

4

ET

March 10, 2010 1:30:26 PM

Shop Packet Print

Page 2

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 verified : DD

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

110

Each

73.0000

3 1.0000



Mounting Channel

25 10-05-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST018

73

53798

13

55313

60

MS21042L3

Purchased

No

110

Each

2,353.000

3 4.0000



Nut

x3

25 10-05-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

2353

110844

35

111274

27

111668

58

112314

285

112385

228

113523

20

113537

700

113644

1000

NAS 1149 003635

AN960JD10

Purchased

No

110

Each

0.0000

3 4.0000



Washer

2 114292

x3

25 10-05-12

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Shop Packet Print

Page 3

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 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

160

Each

1,717.000 8.0000



Rivet, Universal Head

10-5-13 S

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST319

1717

111916

1717

AN3-4A

Purchased

No

160

Each

1,920.000 6.0000



Bolt

6
10-5-13 S

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

1920

104214

393

104291

300

104322

200

104374

200

104625

300

104817

527

6

March 10, 2010 1:30:26 PM

Shop Packet Print

Page 4

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Page 5

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Required Date: 18/03/2010

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IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
verified : DD

Start Qty: 1.00

Required Qty: 1.00

D2237 Manufactured No 160 Each 63.0000 3.0000



Striker Plate



10-5-13SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST010 63

55006 16

55312 47

D2589 Manufactured No 160 Each 0.0000 1.0000



Keys, Key Chain, 350 Hinge

MS21042L3



Nut



3 1358194 10-5-13SP

Purchased No 160 Each 2,353.000 6.0000



10-5-13SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 2353

110844 35

111274 27

111668 58

112314 285

112385 228

113523 20

113537 700

113644 1000

6

March 10, 2010 1:30:26 PM

Shop Packet Print

Page 5

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOWN
RETURNED
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56807
B010-3-10

RELEASED
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	CH	DART AEROSPACE LTD	
DRAWN	CH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CH	DRAWING NO.	REV. D
MFG. APPR.	CH	D2991	SHEET 1 OF 5
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

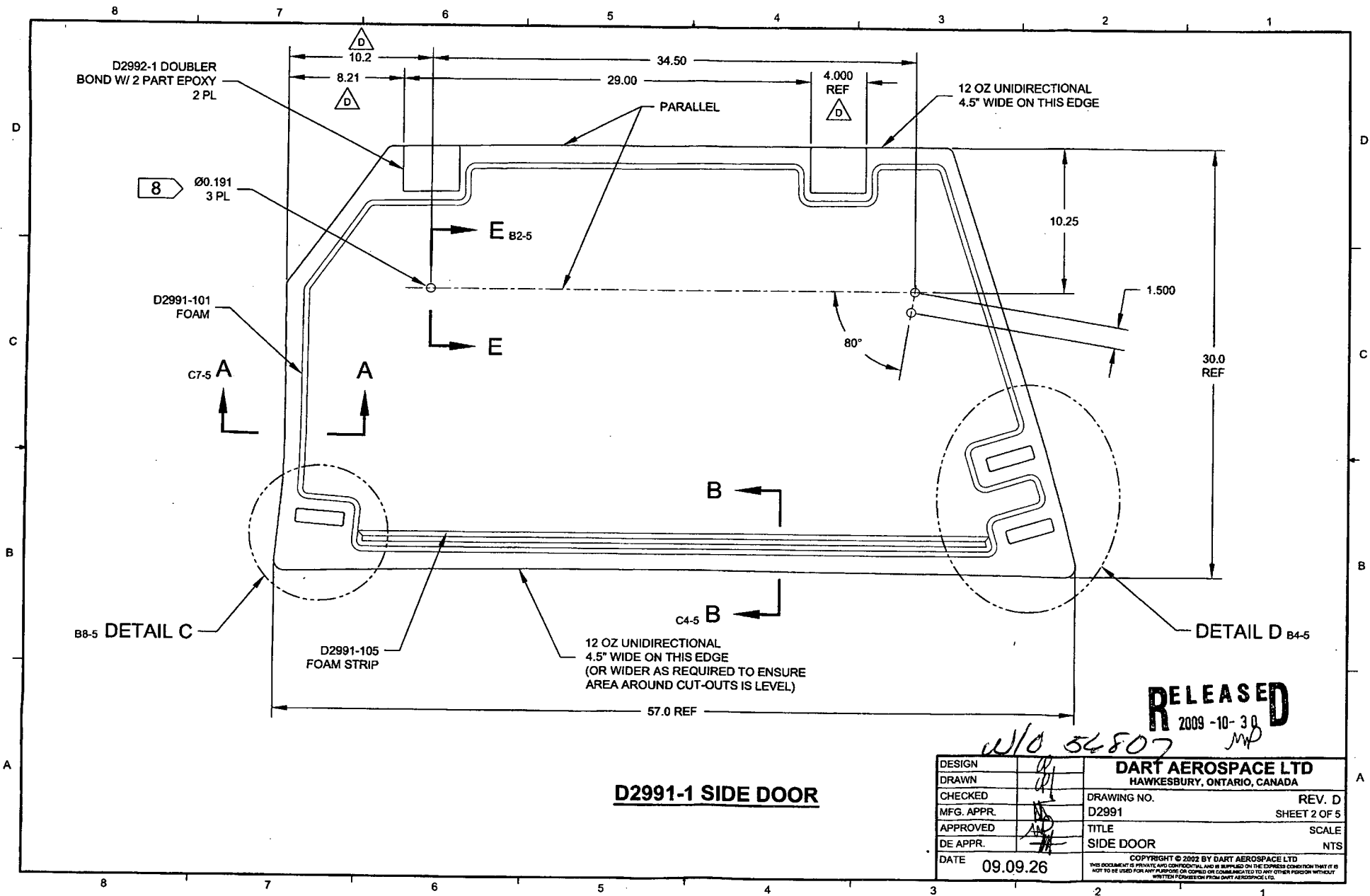
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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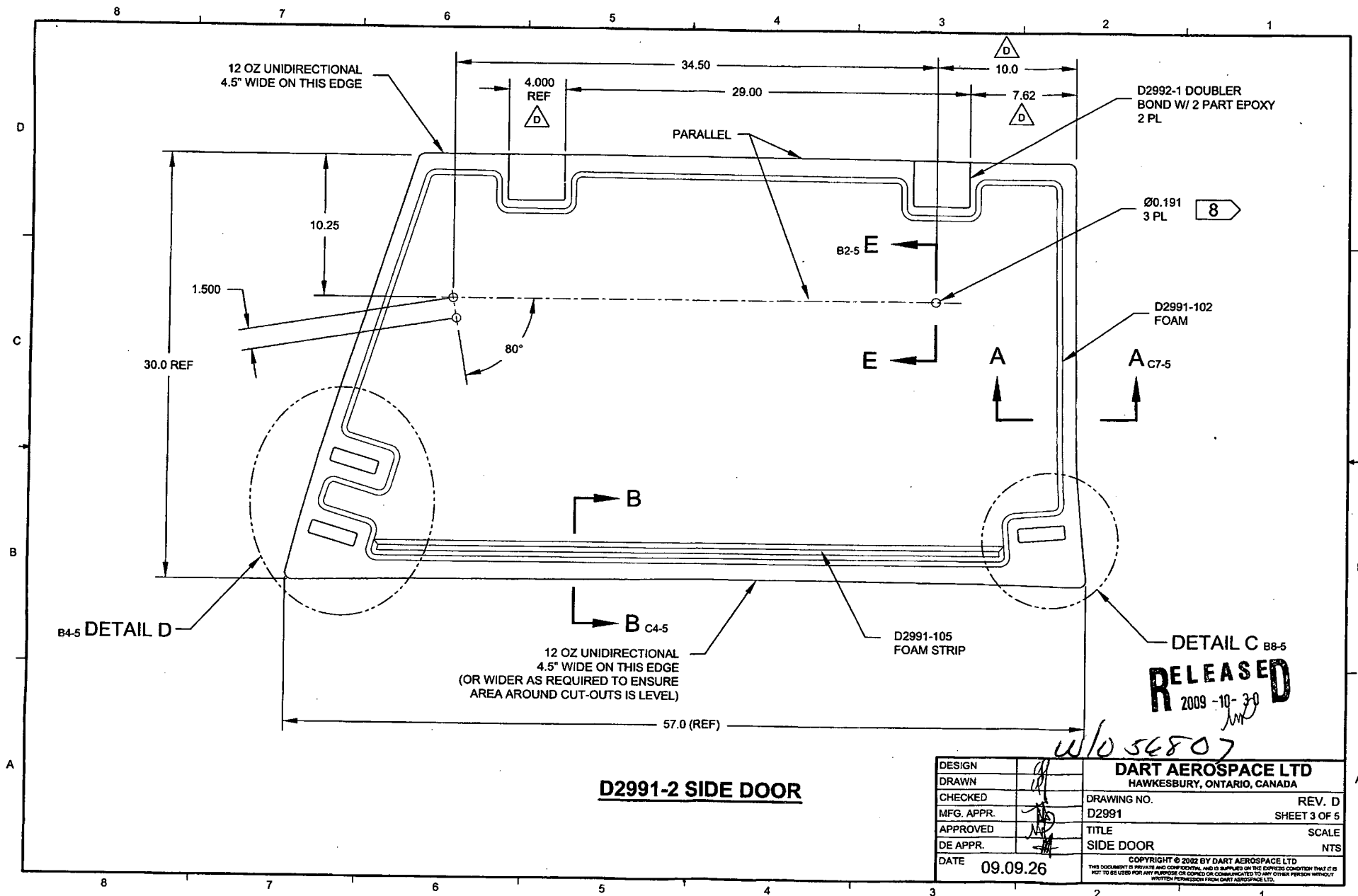
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D2991-2 SIDE DOOR

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
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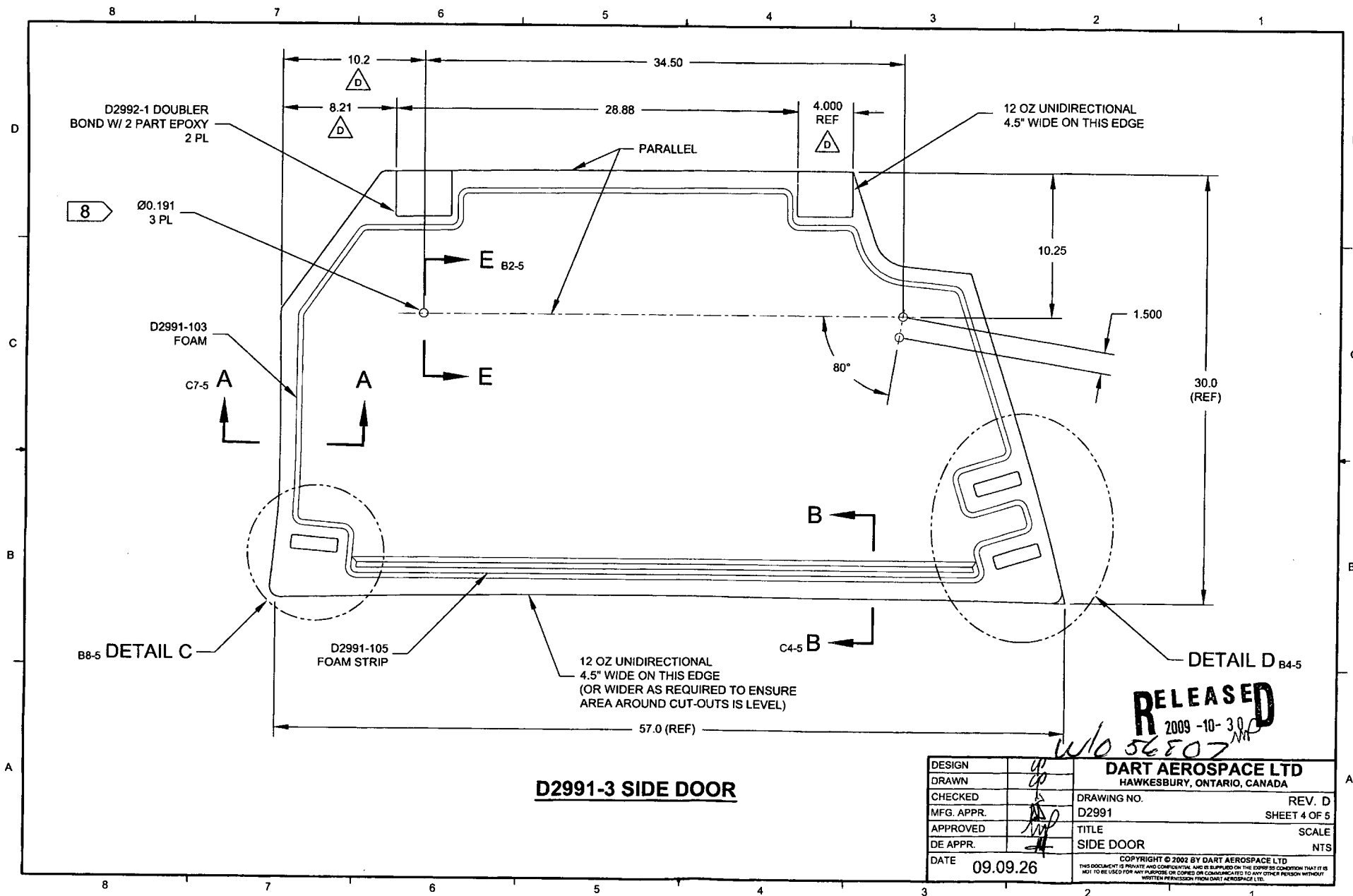
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RELEASED
2009-10-30
W10 56507

DESIGN	W	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	MP	D2991	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

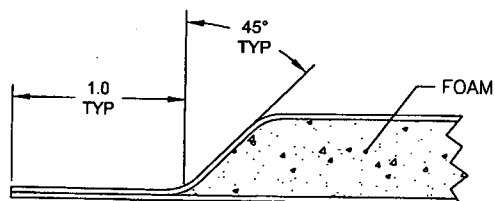
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

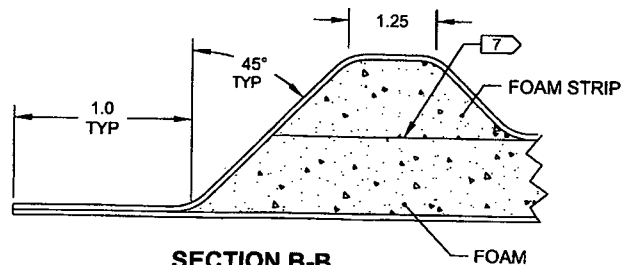
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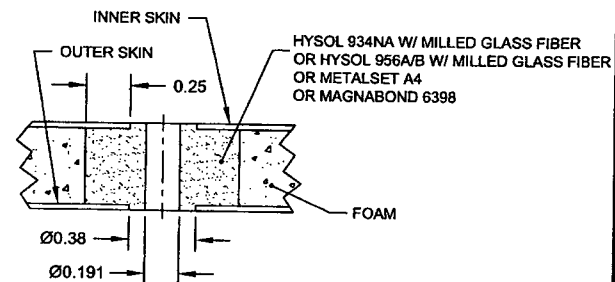
NOTE: Date & initial all entries



SECTION A-A
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

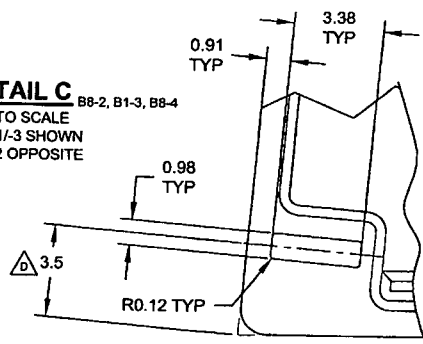


SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

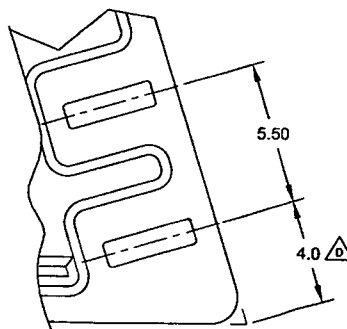


SECTION E-E
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

DETAIL C
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



RELEASED
2009-10-30

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D2991 SHEET 5 OF 5
APPROVED		TITLE SCALE
DE APPR.		SIDE DOOR NTS
DATE	09.09.26	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 54807

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E
AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1
REF CANADIAN STC: SH92-41
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.







Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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A	NEW ISSUE	CP	09.05.26
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9463	SHEET 1 OF 5
APPROVED		TITLE	SCALE
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DATE	09.05.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1110 56807

To install the DSI-9463-011 Door Latch Kit:







- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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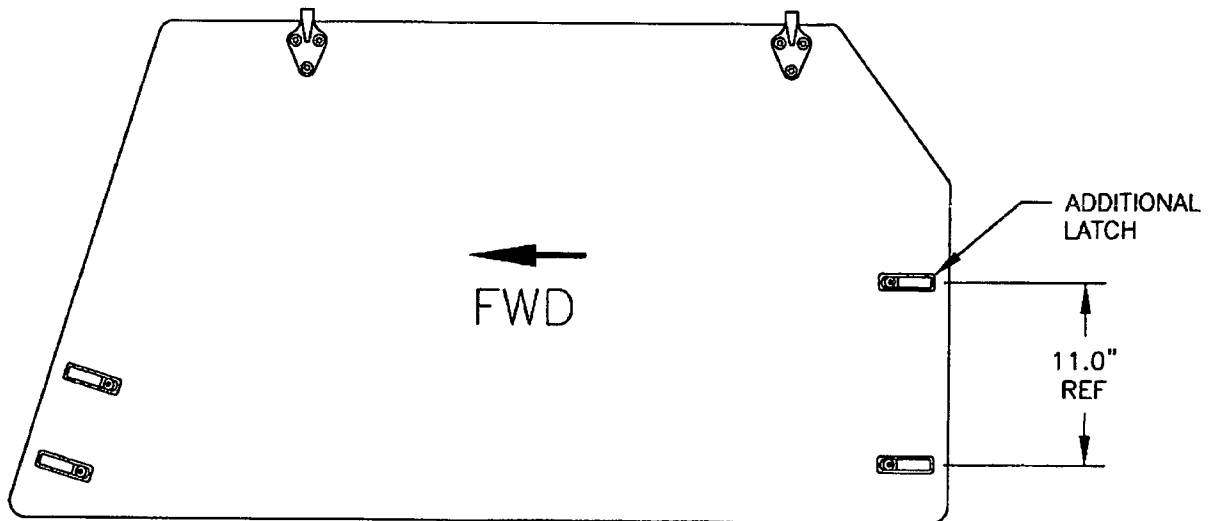
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

**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)
D35X-589-042/-043 (SIMILAR)**

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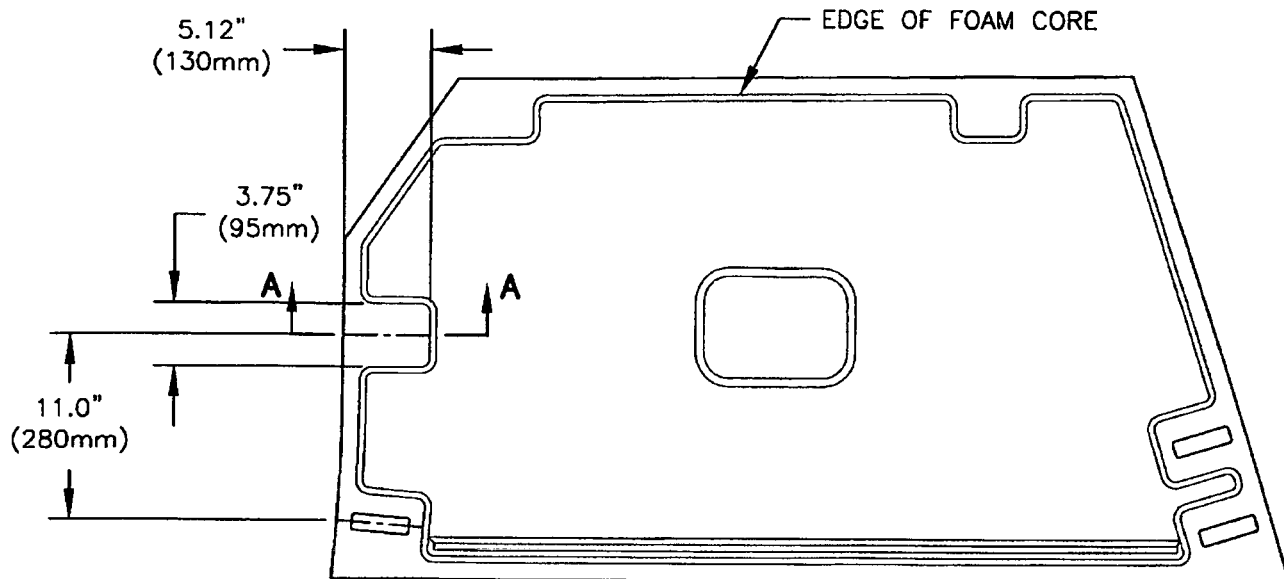
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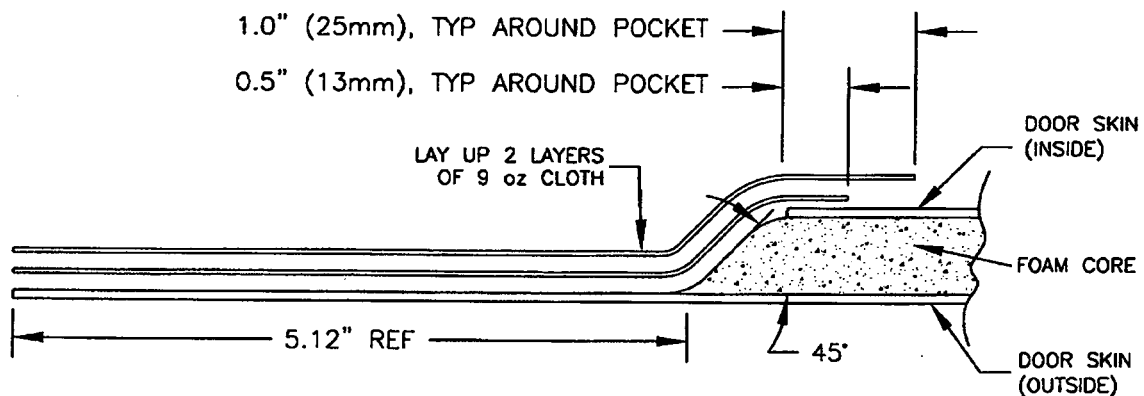
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




**FIGURE 2: TRIMMING FOAM CORE
(VIEW LOOKING AT INSIDE OF DOOR)
(-041 SHOWN. -042/-043 SIMILAR)**



SECTION A-A

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SEE
DETAIL B

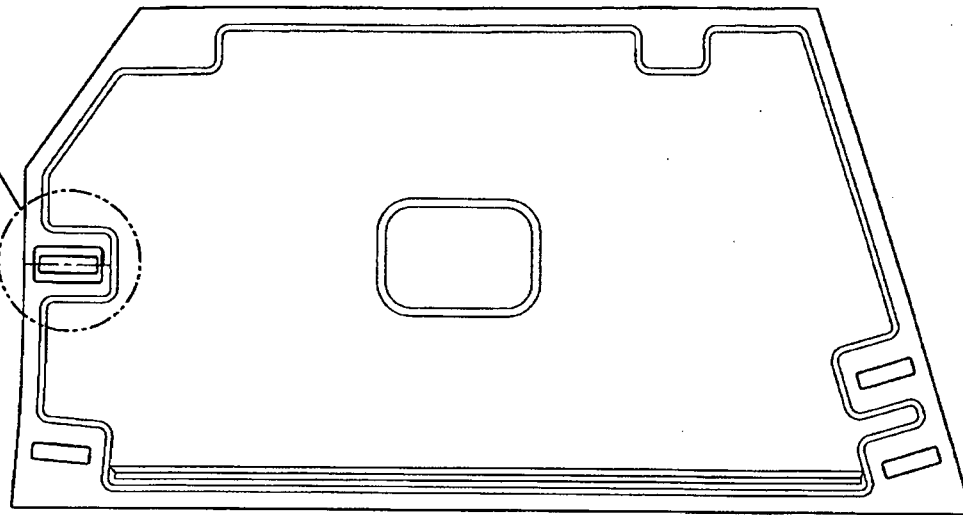
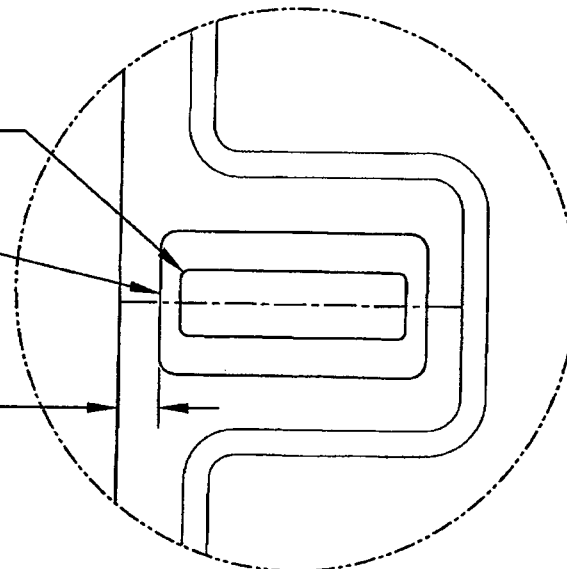


FIGURE 3: CUTTING LATCH HOLE

CUT HOLE THROUGH
SKIN USING D2621 AS
TEMPLATE

D2621 LATCH PLATE

0.60"
(15.2mm)









DETAIL B

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
		1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
	3	3	3	AN960JD10	Washer
	3	3	3	MS21042L3	Nut (or MS21042-3)
	6	6	6	MS20470AD4-5	Rivet
	3	3	3	MS27039-1-15	Screw

Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x Ø0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes Ø0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) M520425AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply zinc tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent non-act wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

DAVID
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 21-0-01

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
 REF. TCCA STC: SH92-41
 REF. FAA STC: SH1012NE
 REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x $\varnothing 0.129$ (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.







There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-C-01	
APPROVED  BY: D. SHEPHERD (DE # 02)	
DATE:	09.02.03
CERT. NO.:	SH92-41
ISSUE NO.:	7

A	NEW ISSUE		09.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. A DSI 9446 SHEET 1 OF 2	
CHECKED		TITLE SCALE SWITCH RELOCATION NTS	
MFG. APPR.	N/A	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED			
DE APPR.			
DATE	09.02.03		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries